



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.4313

Job Sheet 168035



Part No: 647.4313

Job Qty: 4 ea

Part Name: RH Upper Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/24/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.06 CHG
MATERIAL TO S.S. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Large Fab1		DL 17/12/22
110	Waterjet	4 pcs	11/23/17	11/23/17	0.00	0.14	Waterjet1		DL 17/12/22
120	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC2		DL DAS
130	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC8		38
140	Small Fab	4 pcs	11/23/17	11/23/17	0.00	1.42	Small Fab		DL 9-88 18/01/10
150	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC5		EL
160	Large Fab	4 pcs	11/23/17	11/23/17	0.00	1.60	Large Fab 1		DL 18/01/10
170	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC9		EL
180	QC	4 pcs	11/23/17	11/23/17	0.00	0.00	QC5		EL
190	SprayPaint	4 pcs	11/24/17	11/24/17	0.00	0.27	Spray Paint		AS JAN 16 2018
200	QC	4 pcs	11/24/17	11/24/17	0.00	0.00	QC14		DO 11 JAN 17 2018
210	Packaging	4 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		CCO 35 4T 18/01/17
220	QC21-SA	4 Ea	11/24/17	11/24/17	0.00	0.00	QC21		DL

Part Op 110 - 1-Cut 647.4312 plate 3.928X1.985 as per Dwg

Descriptions: 140 - 1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg

160 - Weld tube to plate as per dwg.

190 - Prime as per dwg (see note 4) 138374

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	StcQty
90-Start up Operation	M304S16GA	0	52	0	0
140-Small Fab	M304TR0.500W.049	7	41	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S026532



RH Upper Strut

PART NO:
Revision:
Operation:
Change No:

647.4313

Start up Operation

Mfg Date: 12/22/17
Job No: 168035

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04048

SHEET 1 OF 1

DWG NO. 647.4300

REV: N/C

PREPARED
BY

D. PETERS

DATE: 08/12/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: STRUT

APPROVED BY:

ENGR

MFG

QC

EFF

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR:

NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168035
DAS
30
9-89

NOV 13 2017

DOCUMENTS EFFECTED:

☐ RFMS

☐ MDL

☐ INSTALL INSTRUC

☐ ICA

☐ BOM

CHANGE CATEGORY

☐ MAJOR

☒ MINOR

DER REVIEW REQUIRED

☐ YES

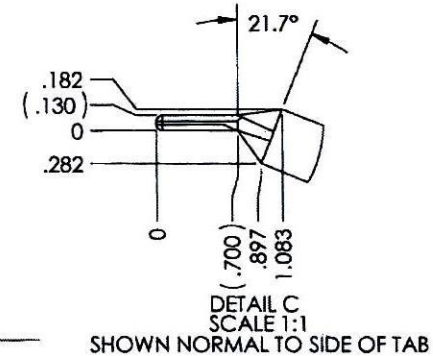
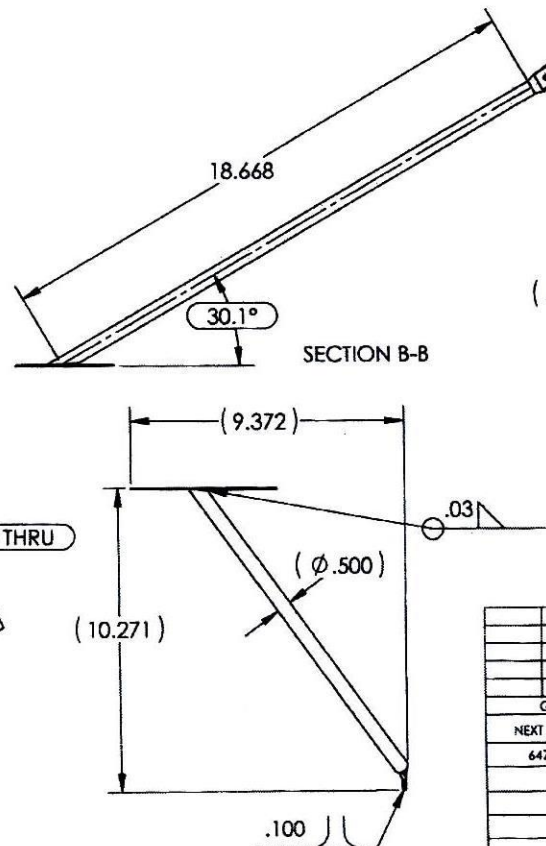
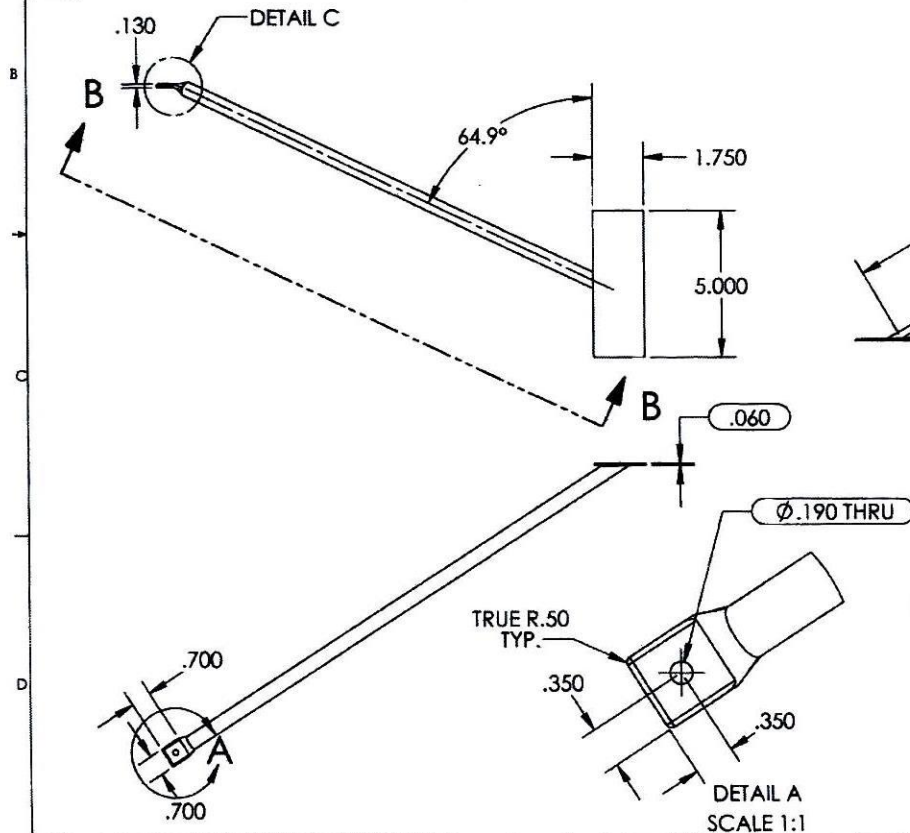
☒ NO

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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 4130 STEEL PER AMS-S-18729, .06" THK.
2. MATERIAL: 4130 STEEL PER AMS-S-18729, .13" THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .049" WALL THK.
4. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PP1		
N/C	INITIAL RELEASE	10/07/09	P. BRAVO
A	INCORPORATED ECN 04048	08/12/13	P. BRAVO



647.4310 SHOWN
647.4311 OPPOSITE

QTY	647.4313	RH UPPER STRUT	△△△△	△△△△
NEXT ASSY (S)	647.4312	LH UPPER STRUT	△△△△	△△△△
647.3700	647.4311	RH LOWER STRUT	△△△△	△△△△
	647.4310	LH LOWER STRUT	△△△△	△△△△
	REV	DESCRIPTION	MATL	SPEC
	ORIGINAL DATE	DESIGNED BY		
	APPROVED BY	DESIGNED BY		
	DATE	DATE		
	CONTRACT NO.			
	UNLESS OTHERWISE SPECIFIED			
	TOLERANCES ARE IN INCHES			
	2 PLACE DECIMALS			
	3 PLACE DECIMALS			
	ANGLES ± .5°			
	DATE	DATE		
	SCALE	SCALE		
	SCALE	SCALE		

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

STRUT

647.4300

SCALE NONE

SHEET 1 OF 2

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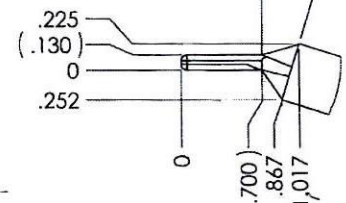
647.4312 SHOWN
647.4313 OPPOSITE

DETAIL F
SCALE 1:1
SHOWN NORMAL TO SIDE OF TAB

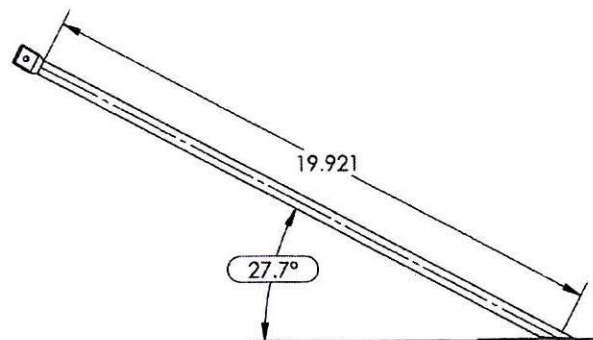
ORIGINAL DATE: 10/01/20		DESIGNED BY: D. BARKER	
DRAWN BY: V. POSA/NO		CHECKED BY: D. BARKER	
DRAWING APPROVAL: P. RAYO		CONTRACT NO:	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TO FRACTIONS ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SET: B	CAGE CODE: 07M76
		DWG. NO:	647.4300
		SCALE: NONE	REV: A
		SHEET 2 OF 2	

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OCEANSIDE, CA. 92056-3512 (760)724-5300

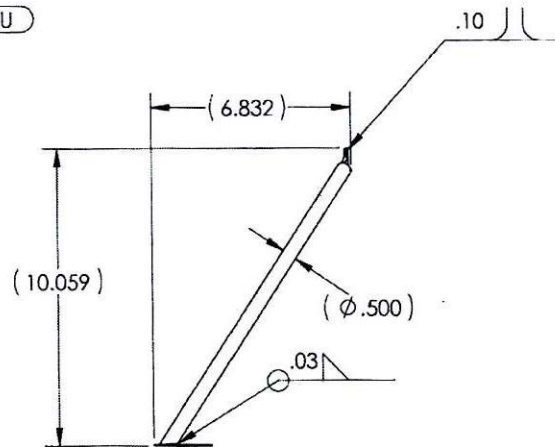
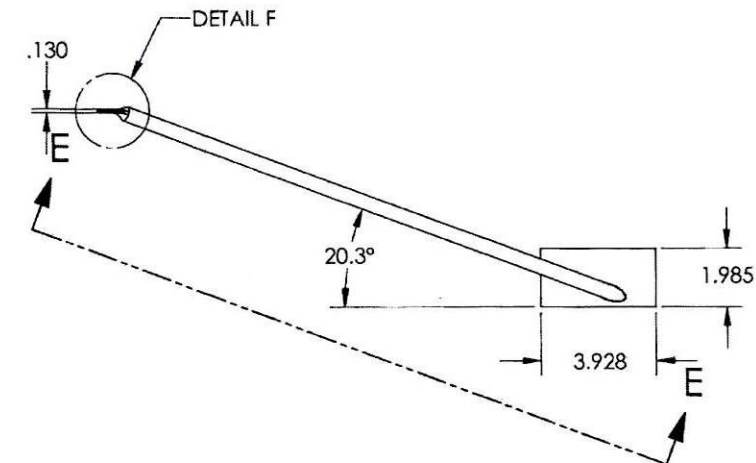
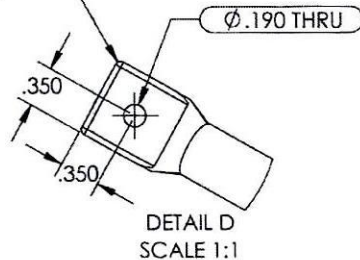
STRUT



SECTION E-E



TRUE R.050
TYP.



.060

(10.059)

(6.832)

(Ø.500)

.03

.10



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number ▲	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 647.4313 Revision: RH Upper Strut														
220	QC21-SA	S026532	168035	4 Ea	0	S026532	CCK075		Stock	12/22/2017	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: M304S16GA Revision: 304/316 Sheet .063														
100	Receive sf	S026530	168035	0 sf	0		Start Up Large Fab-1		Stock	12/22/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Part Number: M304TR0.500W.049 Revision: 304 Round Tube .500 X .049W														
100	Receive Ft	FM138184-1	168035	12 ft	0	M138184	Small Fab		Stock	10/10/2017				
Operation Totals:		1		12	0									
Part Totals:		1		12	0									
Totals:		3		17	0									

Plex 1/19/2018 10:15 AM dart.Gagnon.Michelle